

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010761**Date Inspected:** 19-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang/ Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

CB5

FCAW welding on weld joints 009~012 located at BP201-005. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

6AE

FCAW welding on weld joints 034~038 located at BP206-005. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

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6CE

SMAW welding on weld joints 085~090 located at CA030 on bike path side of segment. Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345+485-SMAW-3G(3F)-Repair-1.

6CE+6BE

SMAW welding on weld joint 003 located at OBE6C on bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

SMAW welding on weld joint 003 located at OBE6C on bike path side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

SMAW welding on weld joint 003 located at OBE6C on bike path side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U2-FCM-1.

5CW

SMAW welding on weld joint 002 located at CA021 on counter weight side of segment. Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Tc-U4b-FCM-1.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

6CE+6BE

1. Heat straightening in progress of Longitudinal Diaphragm between panel points 37 and 36 per HSR1 (B)-7875 cross beam side of segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for

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your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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